






# Work Order ID 52843

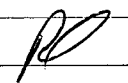


October 15, 2009 12:36:25 PM



Page 1


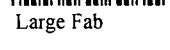
Item ID: D3805-043 Accept  Setup Start   
Revision ID: A Stop   
Item Name: Wearplate Assembly Fwd, High Gear  
Start Date: 15/10/2009 Start Qty: 5.00  Cust Item ID:  
Required Date: 27/10/2009 Req'd Qty: 5.00  Customer:

## Reference:

Approvals: Process Plan:  Date: 24-10-15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3805	Rev A

100  0.00  
Large Fab  Memo 0.00  
Large Fab

1- on D3806-3, fill cut outs with hardcoat welding rod as per dwg D3805  
2059 B Hardcoat Welding Rod  
BATCH#: 112963  
2-weld D3806-3 to wearplate by positioning holes together as per dwg D3805  
304 S.S. Welding Rod  
BATCH #: 102421

02 9-11-2 (X5)

110  QC 0.00  
Quality Control Memo 0.00

09/11/03

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Page 2

Item ID: D3805-043  
Revision ID: A  
Item Name: Wearplate Assembly Fwd, High Gear

Accept



Setup Start



Stop



Start Date: 15/10/2009 Start Qty: 5.00  
Required Date: 27/10/2009 Req'd Qty: 5.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	=> 07/11/03			(15)	0		
130  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 10:30am OVEN TEMPERATURE: 320°F FINISH TIME: 1:00pm	0.00 0.00	Jel 09/11/03			(15)	0		
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	MD 09/11/03			15			

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Page 3

Item ID: D3805-043  
Revision ID: A  
Item Name: Wearplate Assembly Fwd, High Gear

Accept



Setup Start



Stop



Start Date: 15/10/2009 Start Qty: 5.00

Required Date: 27/10/2009 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Bond D3807-3 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: <u>B 52836</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP21</u>	0.00							
Packaging	Memo	0.00							
Packaging									

09/11/03 (5)

09/11/04

(x5) 4

09/11/04

x5

**Work Order ID 52843**

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Item ID: D3805-043  
Revision ID: A  
Item Name: Wearplate Assembly Fwd, High Gear  
Start Date: 15/10/2009 Start Qty: 5.00  
Required Date: 27/10/2009 Req'd Qty: 5.00  
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/06

ME

09-11-05.

# Picklist Print

October 15, 2009 12:36:32 PM

Page 1

Work Order ID: 52843

Parent Item: D3805-043RevA

Parent Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Loc Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3805-3RevA		Manufactured	No			100	Each	1.0000	5.0000			

Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46930

1

1

D3806-3RevA

Manufactured

No

100

Each

0.0000

5.0000

Bar

D3807-3RevA

Manufactured

No

150

Each

0.0000

5.0000

Gasket

*EZ 9-10-29*

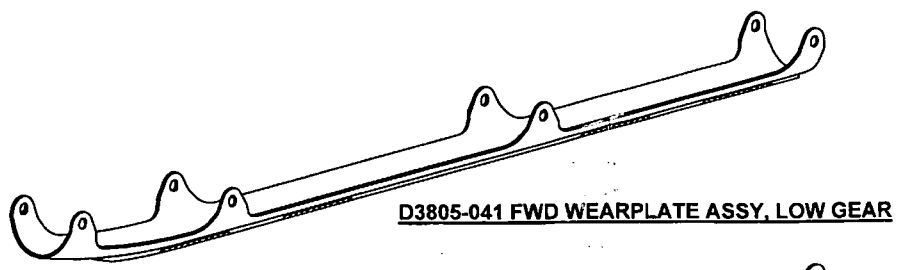
*EZ 9-10-29*

*MR 09-11-09*

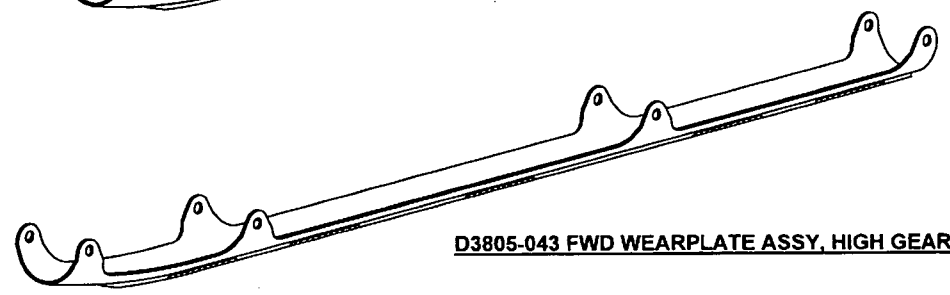
*52853 x5*  
*52852 x5*

*52836*

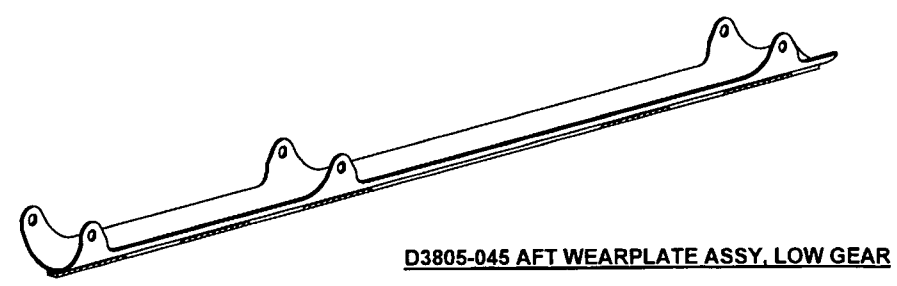
8 7 6 5 4



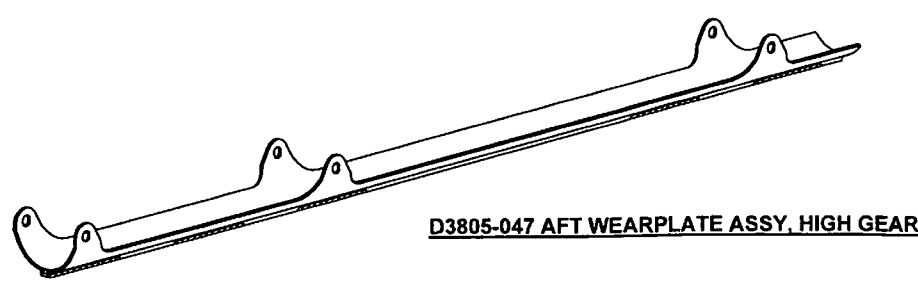
**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**



**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



**D3805-045 AFT WEARPLATE ASSY, LOW GEAR**



**D3805-047 AFT WEARPLATE ASSY, HIGH GEAR**

8 7 6 5 4

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

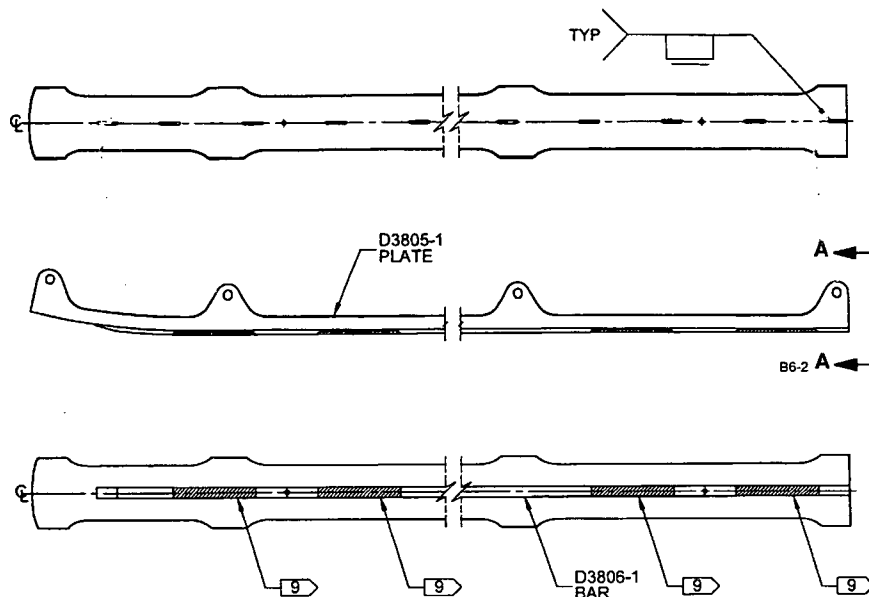
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NO. 52483-52843  
09-10-15

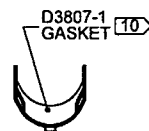
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09-03-03  
PER ECN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D3805</b> TITLE <b>WEARPLATE ASSY</b> SCALE <b>NTS</b>		
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	08.11.21		

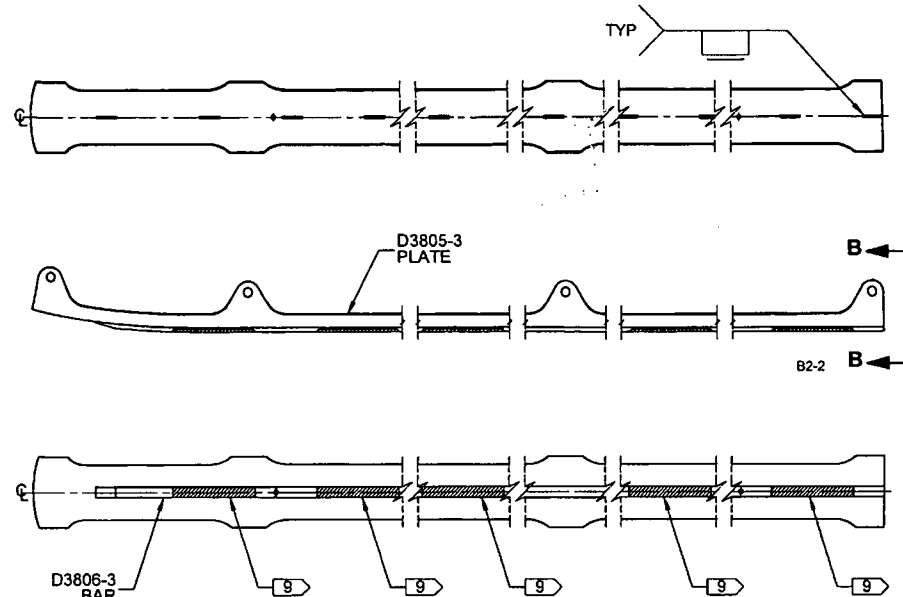
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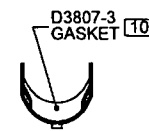
**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**



**VIEW A-A** C5-2



**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



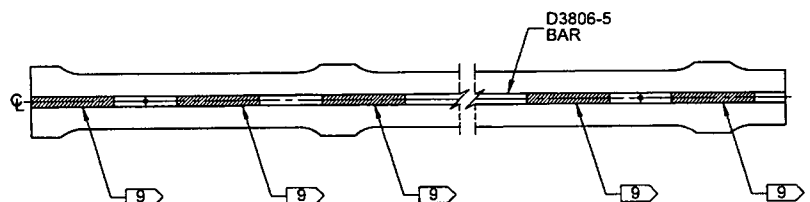
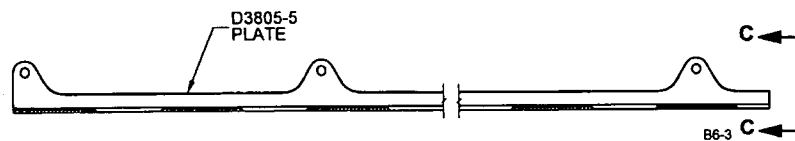
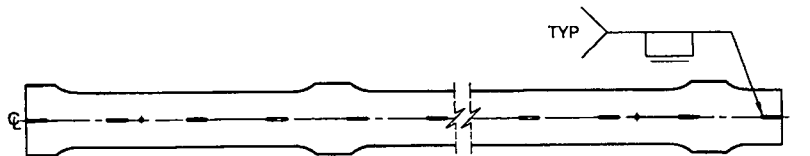
**VIEW B-B** C1-2

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

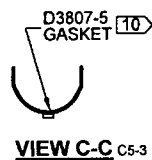
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4 09.03.03

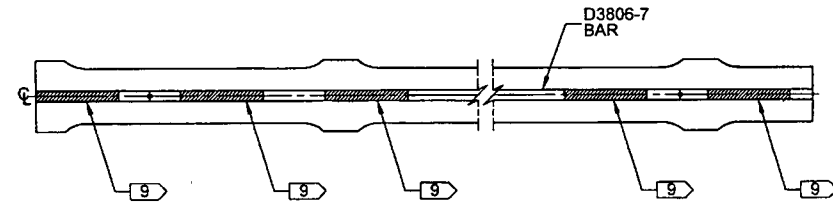
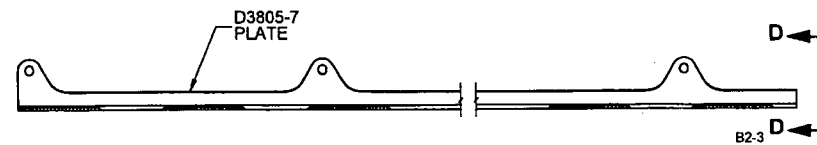
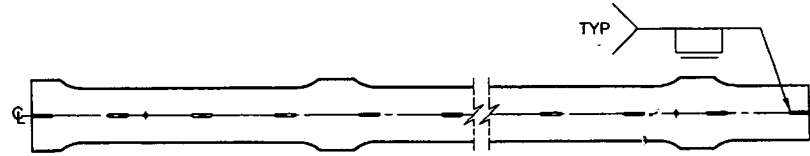
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CHECKED	10	DRAWING NO.	REV. A
MFG. APPR.	10	D3805	SHEET 2 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE ASSY	NTS
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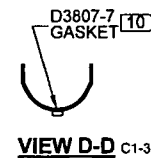
**D3805-045 AFT WEARPLATE ASSY.**



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**D3805-047 AFT WEARPLATE ASSY.**

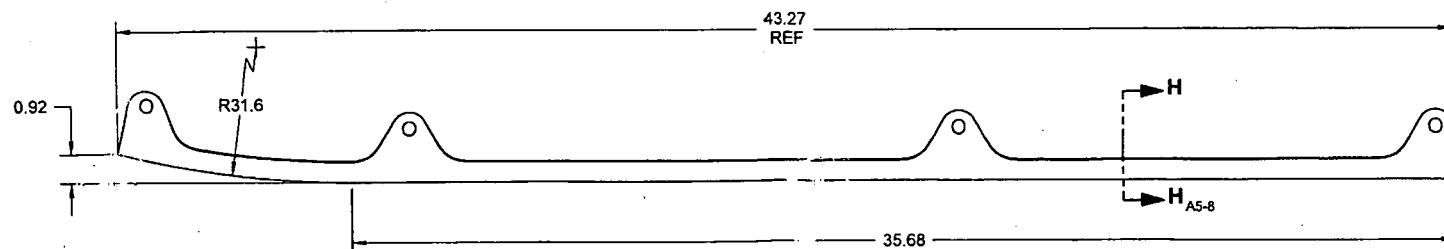


**RELEASED**  
09.03.07

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

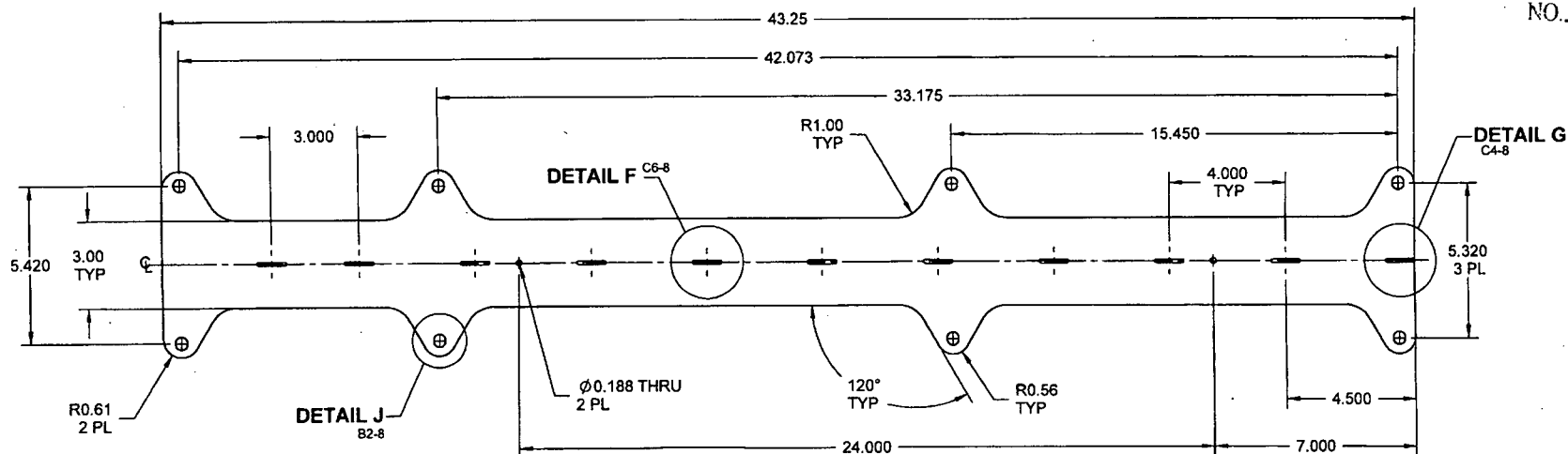
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CHECKED	147	DRAWING NO.	REV. A
MFG. APPR.	147	D3805	SHEET 3 OF 8
APPROVED	147	TITLE	SCALE
DE APPR.	147	WEARPLATE ASSY	NTS
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**D3805-1 PLATE**  
(MAKE FROM D3805-1F)

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NO. 528413



**D3805-1F PLATE**

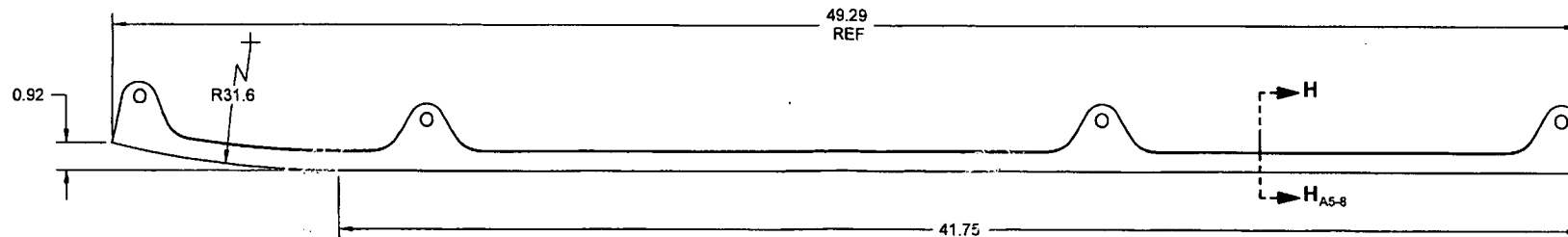
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**NOTES:**

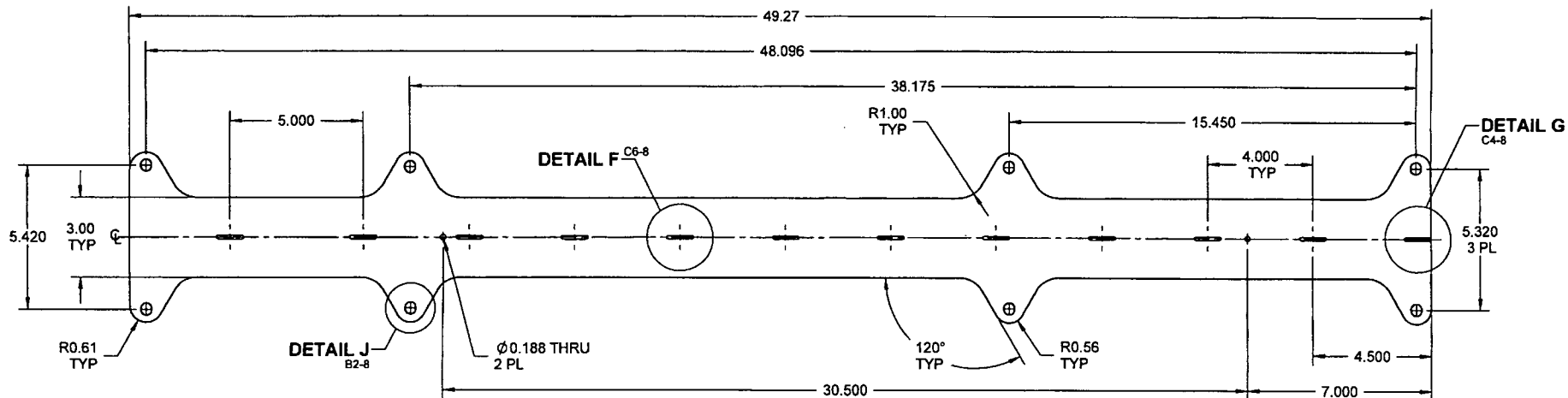
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

DESIGN	197	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	197	PORT HADLOCK, WA	
CHECKED	197	DRAWING NO.	REV. A
MFG. APPR.	197	D3805	SHEET 4 OF 8
APPROVED	197	TITLE	SCALE
DE APPR.	197	<b>WEARPLATE ASSY</b>	NTS
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8 7 6 5 4 3 2 1



**D3805-3 PLATE**  
(MAKE FROM D3805-3F)



**D3805-3F PLATE**

**RELEASED**  
09.03.07

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.37 lbs

NO. 52045  
WORK ORDER  
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DRAWN	AS	DRAWING NO.	REV. A
CHECKED	AS	<b>D3805</b>	SHEET 5 OF 8
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	<b>WEARPLATE ASSY</b>	NTS
DE APPR.	AS	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	08.11.21		

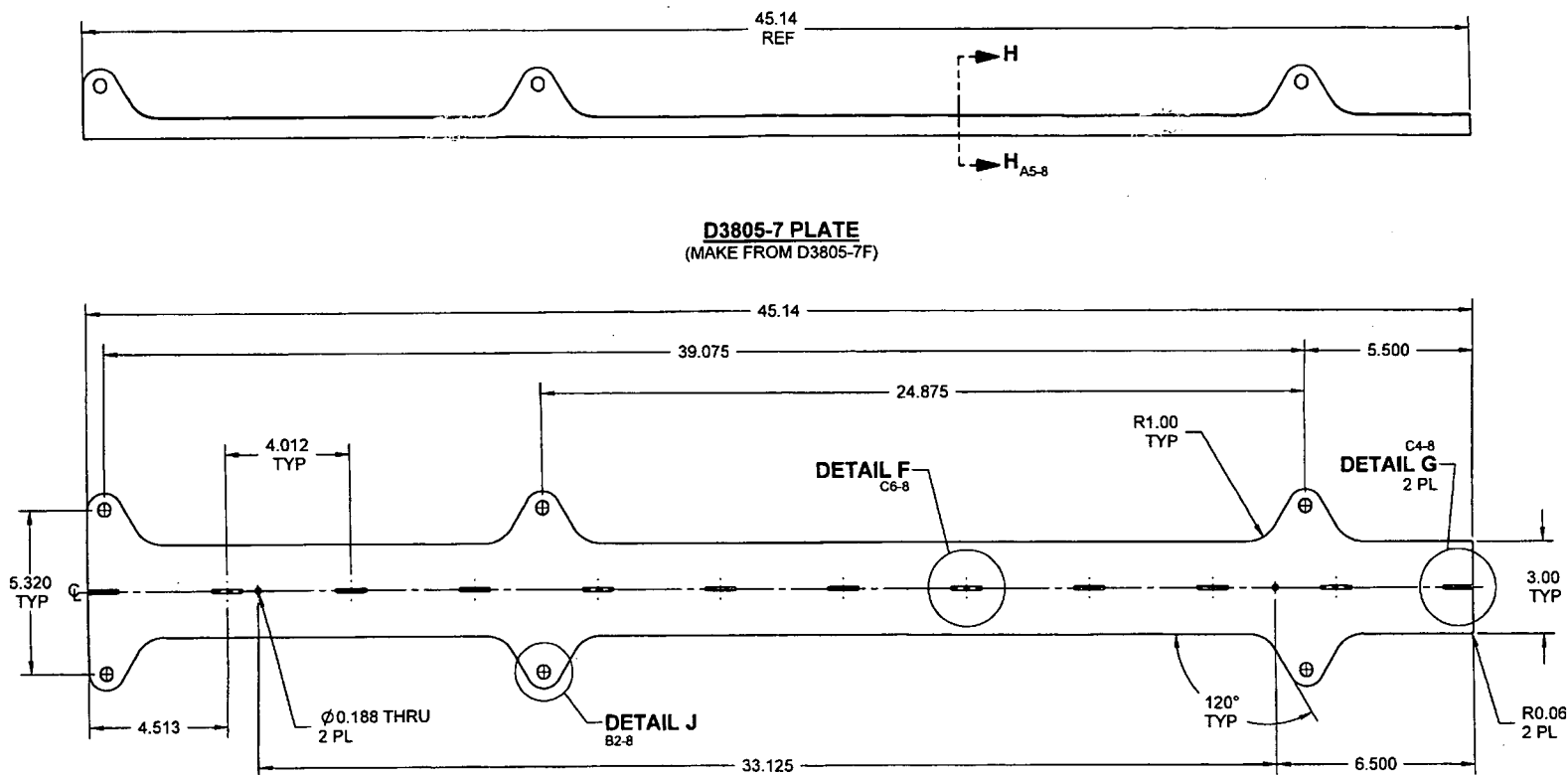


RELEASE  
4 04-03-03

2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 2.06 lbs

4  
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WORK CARD  
NO. 502843

DESIGN	40	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JA	PORT HARDLOCK, WA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	DA	D3805	SHEET 6 OF 6
APPROVED	40	TITLE	SCALE
DE APPR.	JA	<b>WEARPLATE ASSY</b>	NTS
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**D3805-7 PLATE**  
(MAKE FROM D3805-7F)

**D3805-7F PLATE**

**RELEASED**  
49 09.03.07

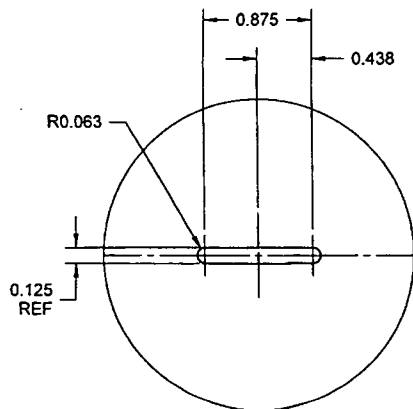
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

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WORK ORDER

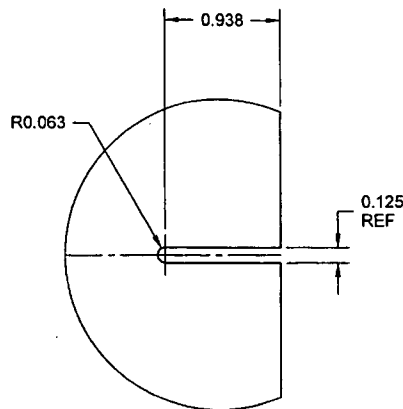
NO. 52843

DESIGN	49	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	49	PORT HADLOCK, WA	
CHECKED	49	DRAWING NO.	REV. A
MFG. APPR.	49	D3805	SHEET 7 OF 8
APPROVED	49	TITLE	SCALE
DE APPR.	49	WEARPLATE ASSY	NTS
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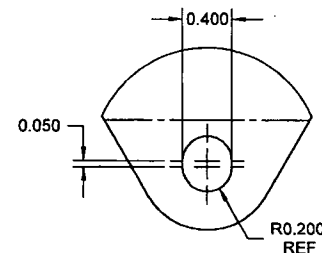
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X

C5-4  
C5-5  
C4-6  
C4-7



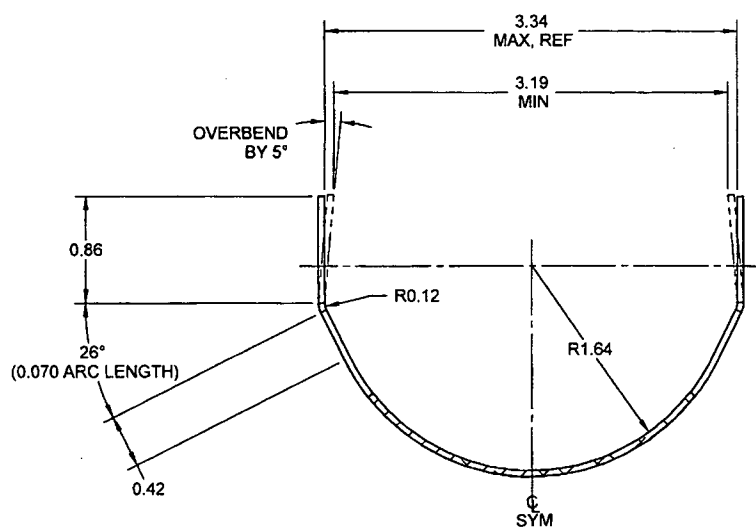
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

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